

Date: Wednesday, 6/6/2007 3:45:50 PM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|---------------------------------------|--|----------------|------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : PLATE | |
| Job Number | : 32839 | | Part Number | : D320411 | |
| Estimate Number | : 10499 | | Drawing Number | : D3204 REV. A1 | |
| P.O. Number | : N/A | | Project Number | : N/A | |
| This Issue | : 6/6/2007 | | Type | : MACHINED PARTS | |
| Prsht Rev. | : NC | | Material | : N/A | |
| First Issue | : N/A | | Due Date | : 6/27/2007 | |
| Previous Run | : 30894 | | Qty: | 10 | |
| Written By | | | Um: | Each | |
| Checked & Approved By | | | | | |
| Comment | : Est:C 06.08.11 Added Step 25 KJ/JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|--|
| 1.0 | M6061T6B0500X01000 | 6061-T6 Bar .50" x 1.0" |
| | | |
| Comment: Qty.: 0.1116 f(s)/Unit Total : 0.6697 f(s) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.5005x01.000) Batch: M18133 | | |
| 2.0 | BAND SAW | BAND SAW |
| | | |
| Comment: BAND SAW Cut blank: 1.00" x 0.50" x 1.150" long Bar (+0.030/-0.000) | | |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
| | | |
| Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA357 and Dwg D3204 2- Deburr Identify as D3204-11 | | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 5.0 | QC8 | SECOND CHECK |
| | | |
| Comment: SECOND CHECK | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/21/18
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 3:45:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 32839

Part Number: D320411

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 76

7/2/17 50 (10x)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/2/17 50 (10x)
7/2/18 (18)

Job Completion



2007/12/17
V

| W/I/O: | | WORK ORDER CHANGES | | | | | |
|--------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 32839 |
| Description: Plate | Part Number: | D3204-11 |
| Inspection Dwg: D3204 | Rev: A1 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

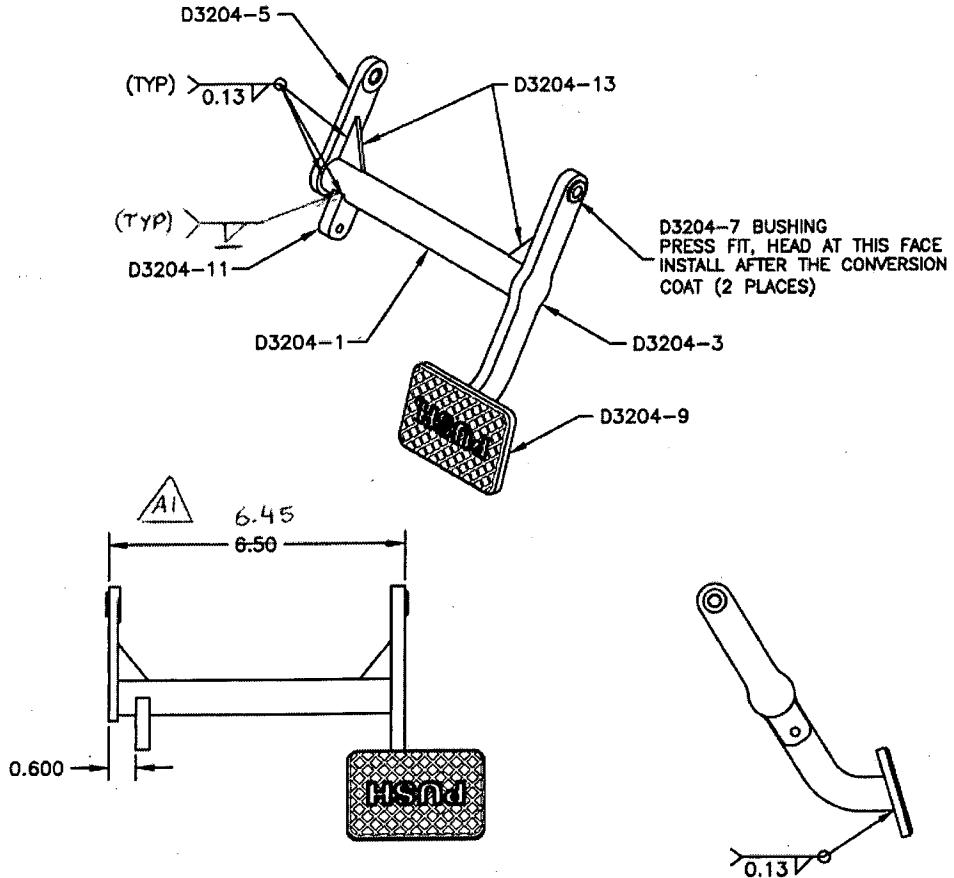
| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | DJP | Audited by: | Andy | Prototype Approval: | N/A |
| Date: | 07/12/14 | Date: | 07/12/14 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------|------------|---|
| A | 05.02.17 | New Issue | KJ/JLM | |
| B | 06.03.21 | Dwg Rev update | KJ/JLM |   |

DART

DRAFT COPY ISSUE

| | | |
|----------|----------|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D3204 |
| DATE | | REV. A SHEET 1 OF 3 |
| 04.01.27 | | TITLE RELEASE PEDAL ASSEMBLY SCALE NTS |
| A | 04.01.27 | NEW ISSUE |
| A1 | 05.07.15 | 6.45 WAS 6.50 |

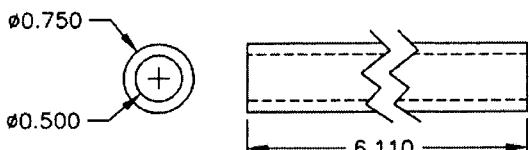
RELEASED
24.04.30**D3204-041 RELEASE PEDAL ASSEMBLY****NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

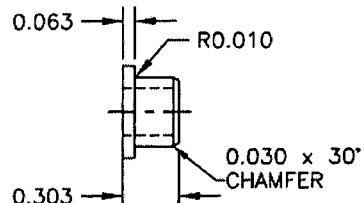
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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER # 32839

DART

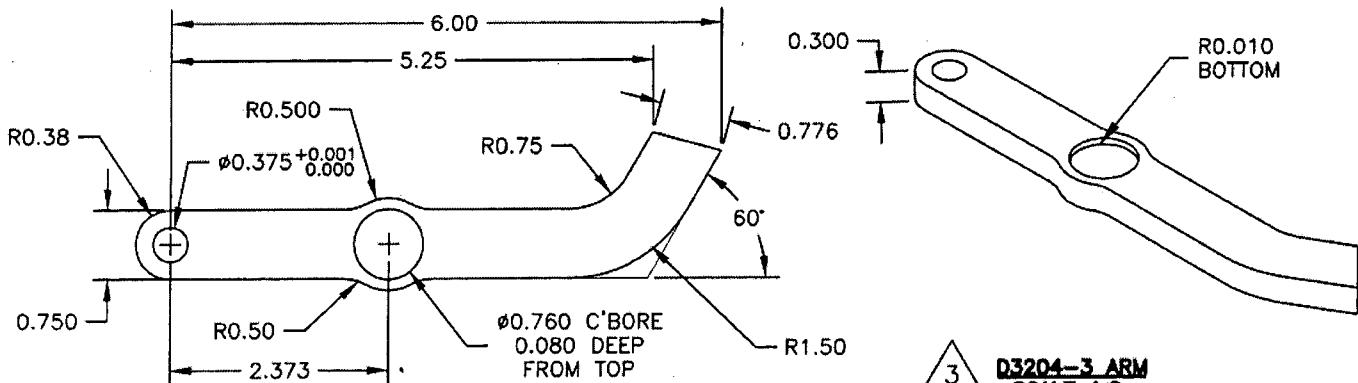
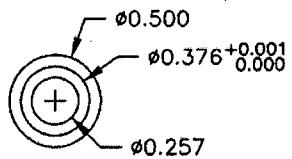
| | | |
|-------------------------------|--------------------------------|---|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3204 |
| DATE 04.01.27 | TITLE | REV. A SHEET 2 OF 3 SCALE NTS |

RELEASED
04.04.05

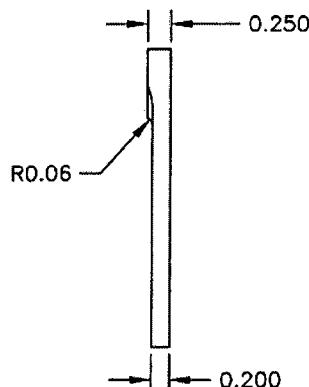
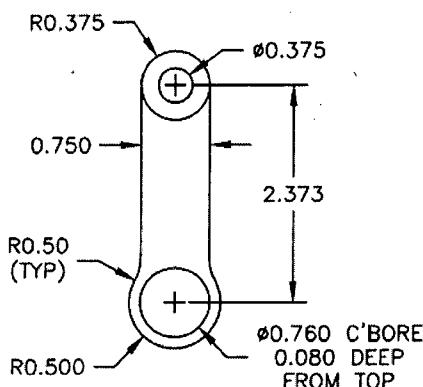
2 D3204-1 TUBE
SCALE 1:2



4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



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R0.010 RETURN TO
BOTTOM ENGINEERING
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NO. 32839

3 D3204-5 ARM
SCALE 1:2

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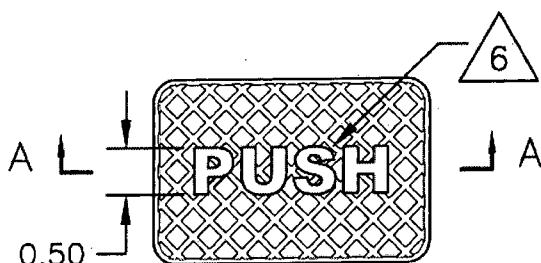
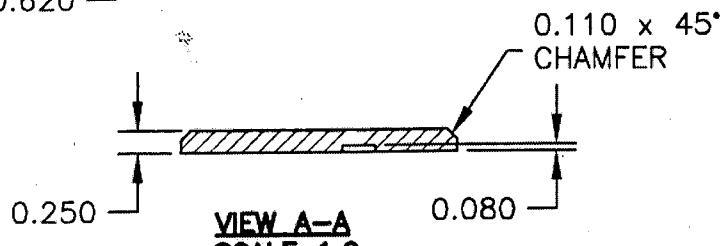
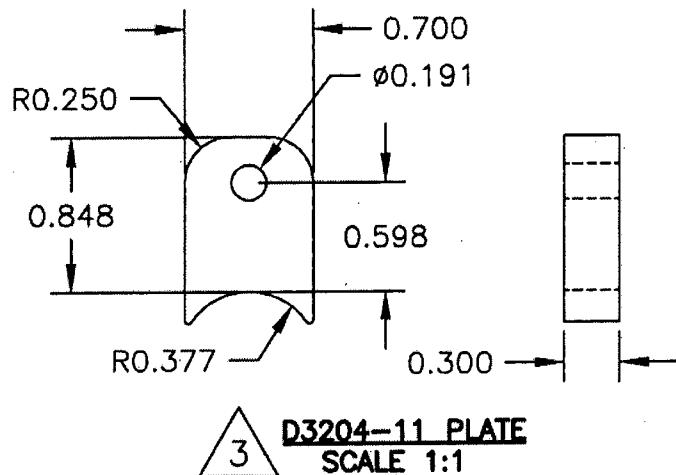
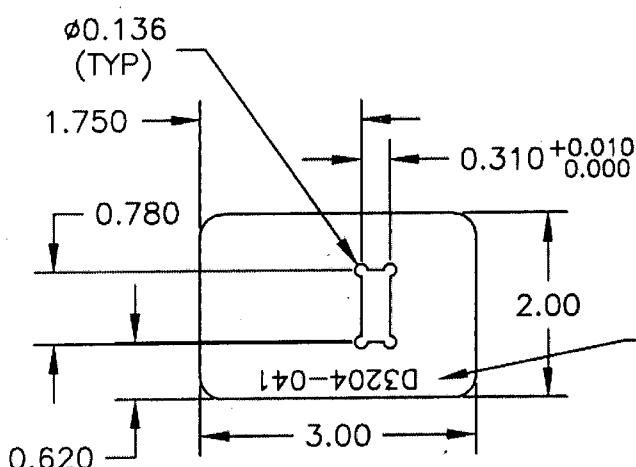
DART

O COPY ISSUE DATE

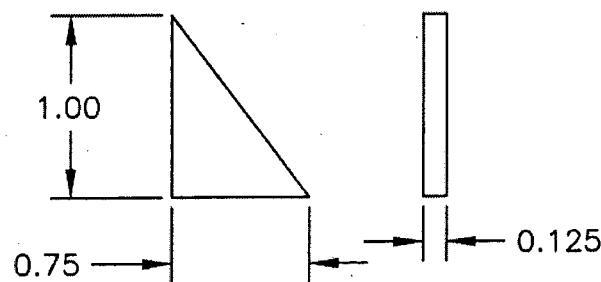
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|----------------------|-----------------------|---|------------------------|
| DESIGN <i>RF</i> | DRAWN BY <i>RF</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>RF</i> | APPROVED <i>RF</i> | DRAWING NO. D3204 | REV. A SHEET 3 OF 3 |
| DATE 04.01.27 | | TITLE RELEASE PEDAL ASSEMBLY | SCALE NTS |

RELEASED

04.04.30



3 D3204-9 PEDAL
SCALE 1:2



5 D3204-13 GUSSET
SCALE 1:1

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